

*J. M. Francis,
Soldering Clamp.*

N^o 55,845.

Patented June 26, 1866.

Fig. 2

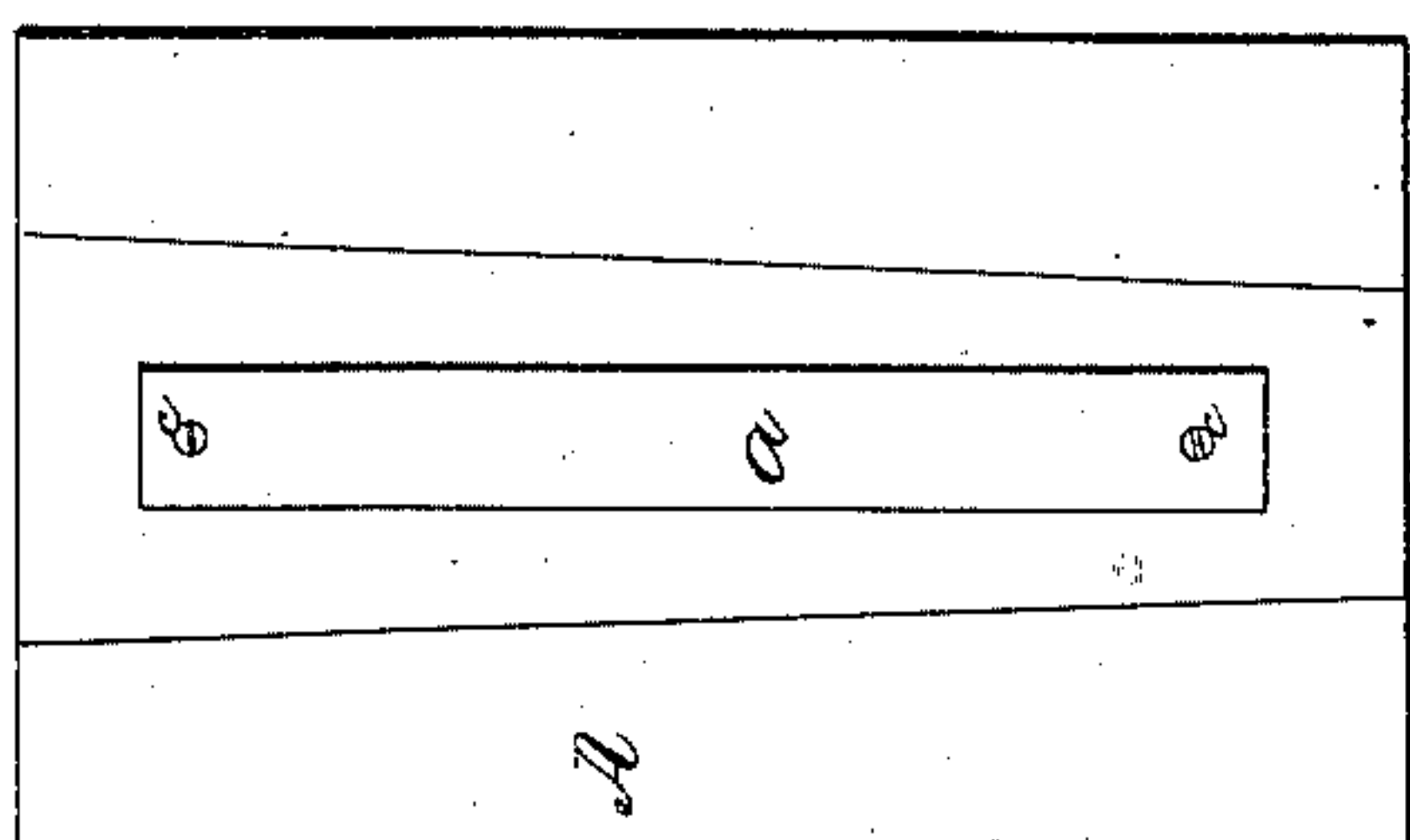


Fig. 3

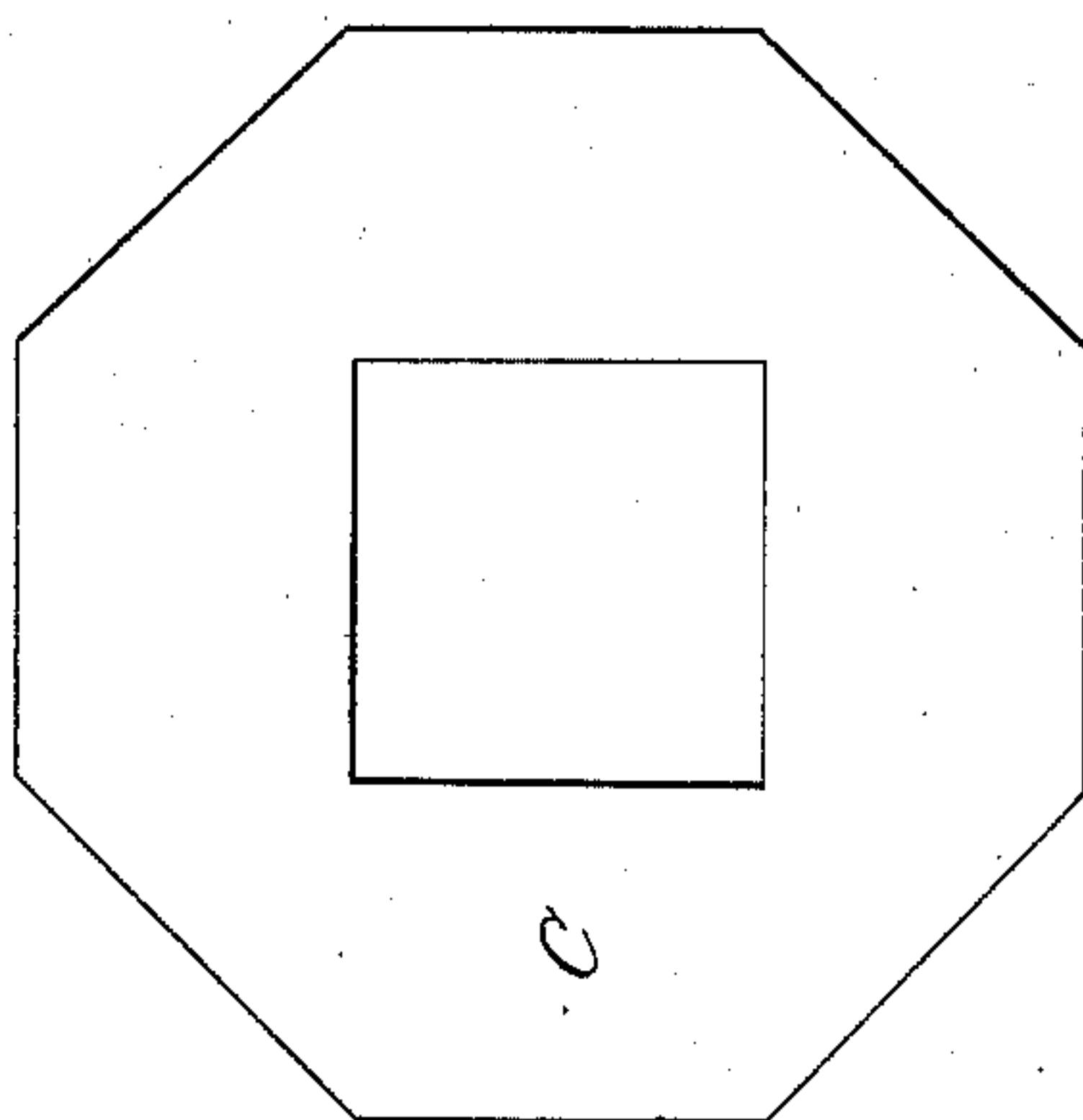
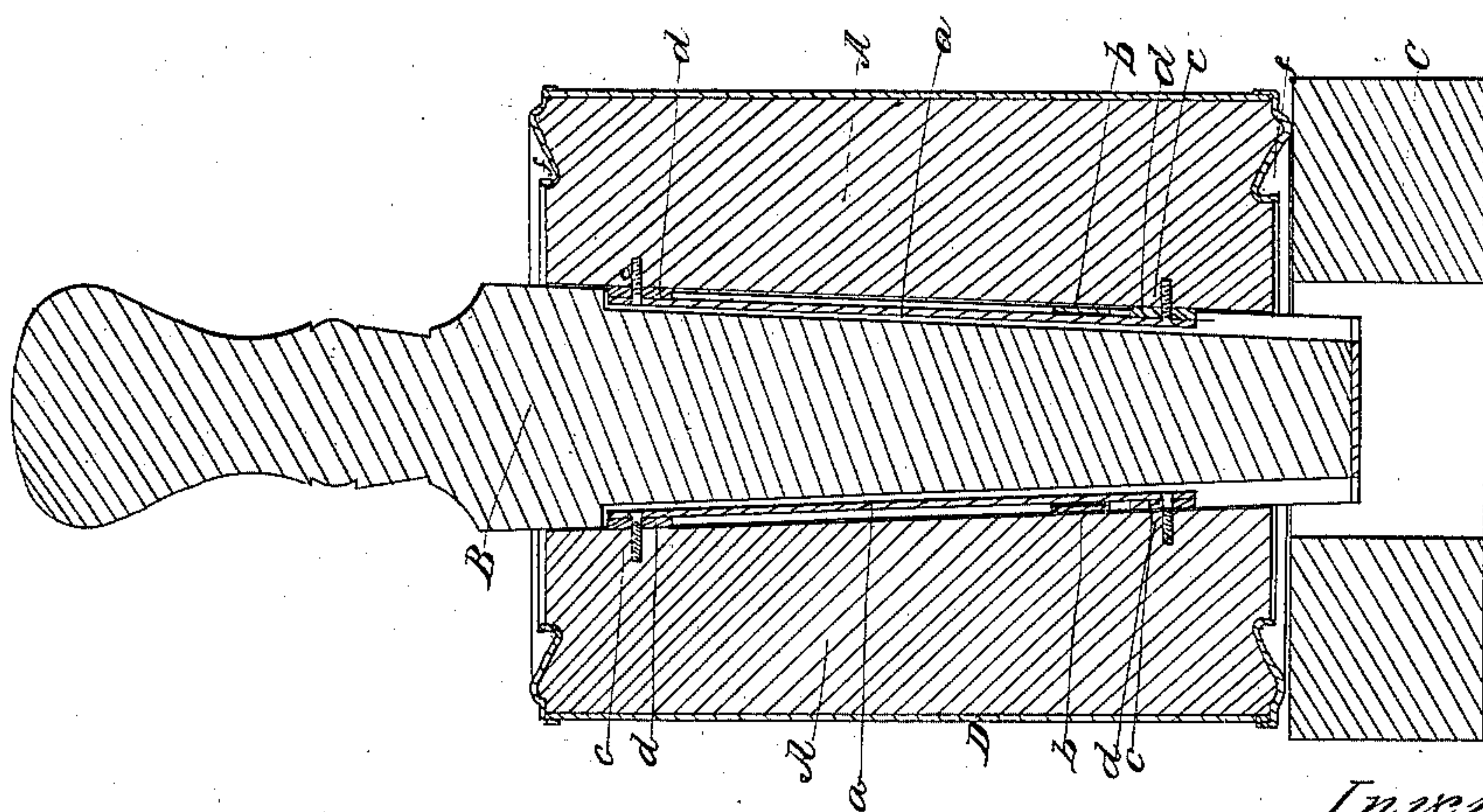


Fig. 1



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UNITED STATES PATENT OFFICE.

JOHN M. FRANCIS, OF WALDO, OHIO.

IMPROVED MODE OF MAKING TIN FRUIT-CANS.

Specification forming part of Letters Patent No. 55,845, dated June 26, 1866.

To all whom it may concern:

Be it known that I, JOHN M. FRANCIS, of Waldo, in the county of Marion and State of Ohio, have invented certain new and useful Improvements in the Mode of Making Tin Fruit-Cans; and I do hereby declare that the following is a full, clear, and exact description of the same, reference being had to the accompanying drawing, and the letters of reference marked thereon, making a part of this specification.

My invention is constructed by dividing a wooden cylinder of the size of the fruit-can into four equal parts or sections, A, the central angles of each being taken off in such a manner that the inner surfaces of each section will form equal inclined planes in the same direction. These inner plane surfaces show the slant or inclination of a quadrangular wedge, B, which is placed in the opening between the four sections A, and acting in an opposite direction, or against the inner planes of said sections. The wedge B has a longitudinal groove made on each of its four faces to admit the strips of metal *a*, which are attached to the inner surfaces of each section and raised slightly above the said sections by small blocks *d* under each end of the strips, said strips being attached, as shown, Fig. 2, by small bolts or screws *c*. These strips slide easily in the grooves in the wedge, and are connected by a small bar, *b*, which crosses the groove on each face of the wedge, and connects the four sections A to the wedge, the strips *a* being between the grooves and the sections.

The operation of my invention is substantially as follows: A sheet of tin, ten by fourteen, cut lengthwise in two equal parts, compose the bodies for two fruit-cans the size of

the drawing herewith presented, or the bodies for two quart cans. Form one of said pieces in the shape of cylinder; then place a pressed top, *f*, over an orifice in a block C; put one end of the cylindrical-formed tin inside the edge (which is raised) of the presser; insert the invention herein described; place a false top, similar to the one referred to, on the bottom of the can, (which is at the base of the wedge B;) then drive the wedge, which presses the sections against the hoop with force sufficient to expand it against the raised edges of the top and false top; solder the side lap and around the top; then loosen the wedge and withdraw the machine, when the real bottom is put on and the can completed.

The tin bands, which are placed upon the top and bottom of the can in my invention are those that are used in the ordinary cans, and can be bought already prepared from almost all tanners or fruit-can makers, while the tops and bottoms of the sections A are provided with small gutters *f*, to correspond with the pressed bands heretofore referred to.

Having thus fully described my invention, what I claim as new, and desire to secure by Letters Patent, is—

The sections A and wedge B, connected by strips *a* and *b*, arranged in the manner, and used substantially as and for the purposes herein set forth.

As evidence that I claim the foregoing I have hereunto set my hand in the presence of two witnesses.

JOHN M. FRANCIS.

Witnesses:

JOEL STROUB,
A. S. DONITHEN.